

THAT WHICH IS CLAIMED IS:

1. A nonwoven fabric substrate for a clothes dryer fabric softener sheet, said nonwoven fabric substrate being formed from substantially continuous filaments having a denier within the range of 2 to 12 denier per filament, said filaments including matrix filaments formed of polyester homopolymer and binder filaments formed a polyester copolymer, and a multiplicity of bonds throughout the fabric at locations where the binder filaments contact other filaments, said bonds integrating the filaments into a coherent nonwoven fabric with a grab tensile strength of at least 6 pounds per inch in the machine direction and 3.5 pounds per inch in the cross-direction, said fabric having a basis weight of no more than 0.50 ounces per square yard and a thickness of from about 0.180mm to about 0.200 mm.
2. The nonwoven fabric substrate of claim 1, wherein the grab tensile strength is at least 7 pounds per inch in the machine direction and at least 4.5 pounds per inch in the cross direction.
3. The nonwoven fabric substrate of claim 2, wherein the thickness is from about 0.190 mm to about 0.195 mm.
4. The nonwoven fabric substrate of claim 1, wherein the nonwoven fabric basis weight is 0.48 ounce per square yard.
5. The nonwoven fabric substrate of claim 1, wherein the filaments have a denier per filament of 5 to 7.
6. The nonwoven fabric substrate of claim 1, wherein the filament have a trilobal cross-section.
7. The nonwoven fabric substrate of claim 1, in which the fabric is formed from 80% to 95% by weight polyethylene terephthalate homopolymer matrix filaments and 5% to 20% by weight polyethylene isophthalate copolymer binder filaments.
8. A nonwoven fabric substrate for a clothes dryer fabric softener sheet, said nonwoven fabric substrate being formed from substantially continuous filaments having a

trilobal cross-section and a denier within the range of 5 to 7 denier per filament, said filaments including 80% to 95% by weight polyethylene terephthalate homopolymer matrix filaments and 5% to 20% by weight polyethylene isophthalate copolymer binder filaments, and a multiplicity of bonds throughout the fabric at locations where the binder
5 filaments contact other filaments, said bonds integrating the filaments into a coherent nonwoven fabric with a grab tensile strength of at least 7 pounds per inch in the machine direction and 4.5 pounds per inch in the cross-direction, said fabric having a basis weight of from about 0.46 to 0.50 ounces per square yard and a thickness of from about 0.190mm to about 0.195 mm.

10 9. A process for producing a nonwoven fabric substrate for a clothes dryer fabric softener sheet, said process comprising extruding substantially continuous filaments, drawing the filaments to a denier within the range of 2 to 12 denier per filament, randomly depositing the filaments on a collection surface for form a filamentary web with a basis weight of no more than 0.50 ounce per square yard, consolidating the
15 web of filaments in a steam consolidator at a surface temperature of less than 100 degrees C to maintain a fabric thickness of from about 0.180 mm to about 0.200 mm, and directing the consolidated nonwoven web through a hot air bonder and forming a multiplicity of bonds throughout the fabric at locations, the bonds imparting to the nonwoven fabric a tensile strength of at least 6 pounds per inch in the machine direction
20 and 3.5 pounds per inch in the cross-direction.

10. A process according to claim 9, wherein the surface temperature of the steam consolidator drum is less than 95 degrees C.

11. A process according to claim 10, wherein said step of consolidating the web of filaments in a steam consolidator includes operating the consolidator at a chest
25 steam flow of less than 12,000 pounds per hour and a drum pressure less than 12 pounds per square inch.

12. A process according to claim 9, wherein the step of extruding substantially continuous filaments comprises extruding a first plurality of polyethylene terephthalate homopolymer matrix filaments from a first set of spinneret orifices and extruding a

second plurality of polyethylene isophthalate copolymer binder filaments from a second set of spinneret orifices, and wherein the step of forming a multiplicity of bonds comprises forming bonds throughout the web at locations where the binder filaments contact other filaments.